<b>Work Orde</b> Thursday, June 0			,								Page 1
Item ID: Revision ID:	D3262-043		A	Accept				s	etup Star		
Item Name:	Canister Assem	nbly					Ru	9	Stop	·	
Start Date: Required Date: Reference:	6/2/2011 6/6/2011	Start Qty: 1.00 Req'd Qty: 1.00			Cust Item I Customer:	D:	, Lu				
Approvals:	Process Plan		Date: 11-06-07	Tooling: SPC (Y/N):	· · · · · · · · · · · · · · · · · · ·	nte:		R	Run Star Stop		
Sequence ID/ Work Center IL	)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revi	ision Nbr							***		
D3262	Е										
		Weld per dwg A/R Alun Large Fab	ninum rod Batch: MIII44						Ø	SE	11/06/20
Large Fab Large Fab		Memo Weld canisto	er assembly as per Dwg D32	0.00 62 using DT8739 to al	ign fittings				•	,	1-100
		QC9- Inspect visual per (	QSI004- Fusion Welds	0.00				AJ	λ.		
		Memo		0.00				/4	11.0	6.02	

Quality Control

QC5- Inspect part completeness to step on W/O

Pressure test as per Dwg D3262

Memo

Dart Ae	rospace Lt	t <b>d</b>	<b>*</b>		·				To the state of th
W/O:			wo	RK ORDER C	IANGES				
DATE	STEP	PR	OCEDURE CHA	IGE		Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
			p.*	<b>v</b>					
								***	A
Part No	):	PAR #:	Fault Categ	jory:		NCR: Yes	No DQA:	Date: _	
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		Description of NC		Corrective Action	Section I	3	Verification	Approval	Approva
DATE	STEP	Section A	Initial Chief Eng	Action Descr Chief Eng	iption	Sign & Date	Section C	Chief Eng	QC Inspecto
		WEST							
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#### Work Order ID 70255

Thursday, June 02, 2011 8:55:44 AM



Page 2

Item ID:

D3262-043

Accept

Setup Start

Stop



**Revision ID:** 

**Item Name:** 

Canister Assembly

**Start Date:** Required Date: 6/6/2011

6/2/2011

Start Qty: 1.00

Req'd Qty: 1.00



**Cust Item ID:** 

**Customer:** 

Reference:

**Approvals:** 

Process Plan:

Date: \_\_\_\_\_

Date: Tooling:

SPC (Y/N):

Set Up/

**Run Hours** 

**Tool ID** 

Date:

Date:

Tool # Plan

Code

Run

Oty

Accept

Qty

Start



Stop

Reject Reject

Number

Insp.

Stamp

Sequence ID/

Work Center ID

130

HandFinish

Operation Description

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

Hand Finishing

140

Powdercoat

Powder Coating

Memo

0.00

0.00

\*\*\*\*Ensure to mask threads \*\*\*\*

OVEN TEMPERATURE:

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

FINISH TIME:

QC3- Inspect Part Finish

0.00

Memo

0.00

150

Quality Control

				1						
W/O:			W	ORK ORDER CH	IANGES					
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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	R	esolution:	Dispositi	on:	Q	A: N/C C	osed:		Date: _	<del></del>
NCR:		1	WORK ORE	DER NON-CONFO	DRMANC	E (NCF	-			
DATE	STEP	Description of NC		Corrective Action	Section B	0:	Verific	cation	Approval	Approval
		Section A	Initial Chief Eng	Action Descri	ption	Sign 8 Date		on C	Chief Eng	QC Inspector
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#### Work Order ID 70255

Thursday, June 02, 2011 8:55:44 AM



Page 3

Item ID:

D3262-043

Accept



Setup Start

Stop



**Revision ID:** 

Item Name:

Required Date: 6/6/2011

Canister Assembly

**Start Date:** 

6/2/2011

Start Oty: 1.00 Req'd Qty: 1.00 **Cust Item ID:** 

**Customer:** 

Reference:

**Approvals:** 

Process Plan: QC: \_\_\_

Date:

Date:

Tooling:

SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Date:

Start Run



Stop

Sequence ID/ Work Center ID

160

Packaging

Packaging

Operation Description

Identify as per dwg & Stock Location:

Memo

0.00

0.00

Tool ID

Tool # Plan Code

Accept Qty

Reject Qty

Reject Insp. Number

Stamp

170

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

- 16/7-18 Mr 6-03

		<i>-</i> 2.0								
W/O:			W	ORK ORDER CH	IANGES		·····			
DATE	STEP	PR	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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DATE	STEP	Description of NC		Corrective Action	Section B		Verific	cation	Approval	Approval
DAIL	J.L.	Section A	Initial Chief Eng	Action Descri Chief Eng	ption	Sign 8 Date		ion C	Chief Eng	QC Inspector
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### **Picklist Print**

Thursday, June 02, 2011 8:55:41 AM

Work Order ID: 70255

Parent Item:

D3262-043

Parent Item Name: Canister Assembly



**Start Date:** 6/2/2011

Required Date: 6/6/2011

Start Qty: 1.00

Required Qty: 1.00

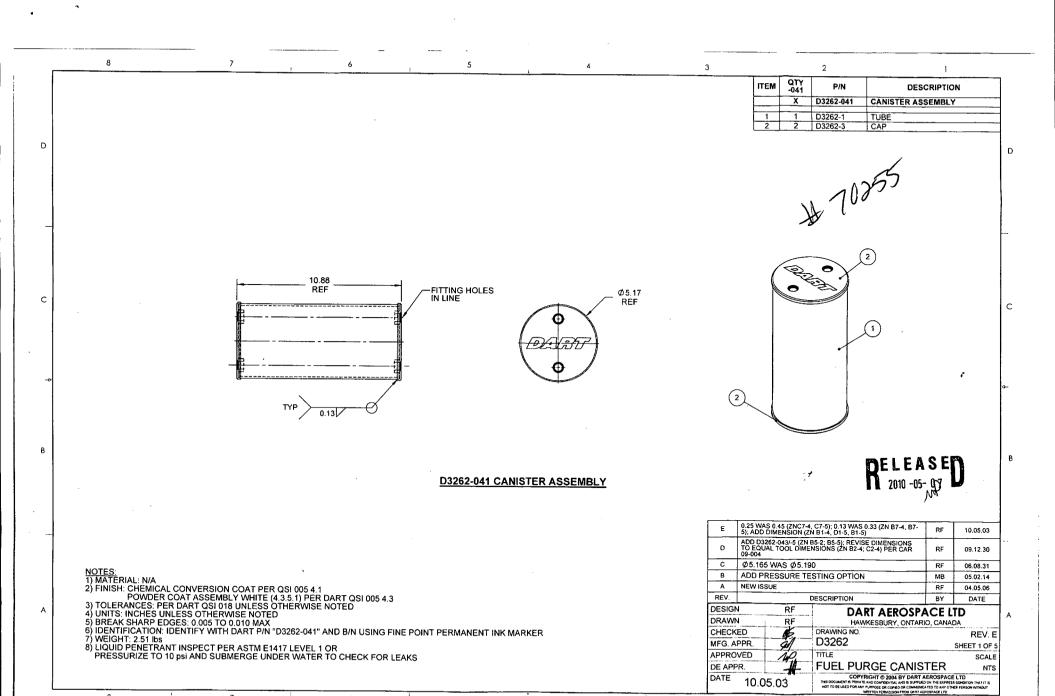
Comments:

IPP rev A 10.01.19 new issue EC verified by: DD as per ECN10-571, DD 10.05.10 verified EC

IPP Rev:B

	as per ECN10-571	DD 10.05.10 ver	ified :E	EC								
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued
D3262-1		Manufactured	No			100	Each	1.0000	1	1	S	\$&u 06/07
				Location	L	<u>Loc</u>	<u>Oty</u>	Loc Code				
				LG002			1				_	
					59740		1		_		_	
D3262-5 Cap		Manufactured	No			100	Each	7.0000	2	2	£	Euloplas
				Location	<u>!</u>	Loc	<u>Oty</u>	Loc Code				
				LG002			7					
					57407		5		_			
					60089		2			<u> </u>	_	

	Johann			1						
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10.05.03

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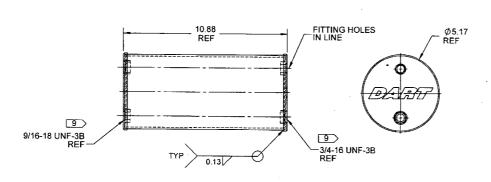
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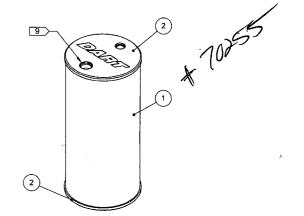
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W/O:			W	ORK ORDER CH	IANGES					
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NCR:			WORK ORI	DER NON-CONF	ORMANC	E (NCR	)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action  Action Description  Chief Eng	Section B ption	Sign &		cation ion C	Approval Chief Eng	Approval QC Inspector
								, , ,		

QTY -043 ITEM P/N DESCRIPTION Х D3262-043 CANISTER ASSEMBLY D3262-1 TUBE 2 D3262-5 CAP





**D3262-043 CANISTER ASSEMBLY** 

NOTES:
1) MATERIAL: N/A
2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "03262-043" AND B/N USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 2.50 lbs
8) LIQUID PENETRANT INSPECT PER ASTM E1442 LEVEL 1 OR 7) WEIGHT: 2010S
8) LIQUID PENETRANT INSPECT PER ASTM E1417 LEVEL 1 OR
PRESSURIZE TO 10 psi AND SUBMERGE UNDER WATER TO CHECK FOR LEAKS
9) WELD CAPS WITH 3/4-16 TAP TOP HOLE IN LINE WITH 9/16-18 TAP BOTTOM HOLE

DESIGN	RF	DART AEROSPACE LTD				
DRAWN	RF	HAWKESBURY, ONTARIO, CANA				
CHECKED	<b>\$</b>	DRAWING NO.	REV. E			
MFG. APPR.	91	D3262	SHEET 2 OF 5			
APPROVED	10	TITLE	SCALE			
DE APPR.	-4	FUEL PURGE CANISTER	NTS			
DATE 10.0	5.03	COPYRIGHT © 2004 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EMPRESS CONDITION THAT IT IS  NOT TO BE USED FOR ANY PURPOSE OR COMEDION AND TO THE PERSON WITHOUT  WRITTEN KYRINGSION FROM DATA TAKENGARGE, TO				

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									<u> </u>	

8 2 Ø5.00 REF D3262-1 TUBE NOTES: 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING, 5.00 OD x 0.125 WALL PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 REF. DART SPEC. M6061T6T5.000W.125 REF. DART SPEC. M6061T6T5.000W.125
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 1.96 lbs DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. E D3262 MFG. APPR. SHEET 3 OF 5 APPROVED TITLE SCALE 8) PART IS SYMMETRICAL ABOUT CENTERLINE DE APPR FUEL PURGE CANISTER

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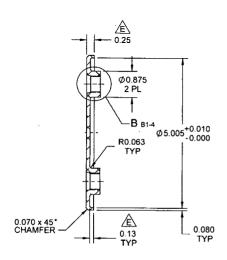
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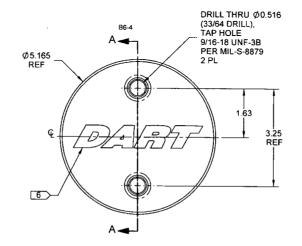
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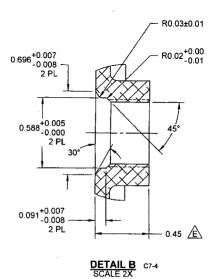
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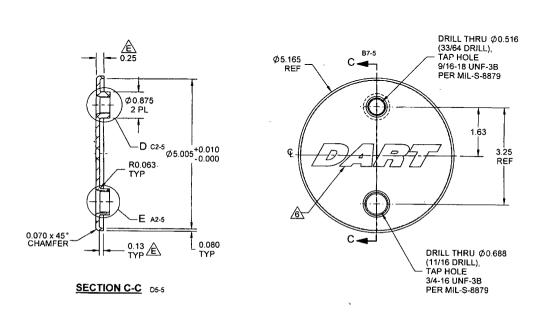
SECTION A-A C5-4

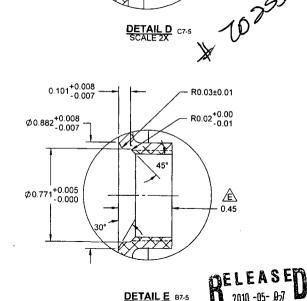
D3262-3 CAP

NOTES: 1) MATERIAL: 6061-T6/T651 ALUMINUM BAR
PER QQ-A-200/8 OR QQ-A-225/8
REF. DART SPEC. M6061T6B
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP
(MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN
7) WEIGHT: 0.28 lbs
8) PART IS SYMMETRICAL ABOUT CENTERLINE
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DESIGN	RF	DART AFROCRACE I	70					
DRAWN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA						
CHECKED	1	DRAWING NO.	REV. E					
MFG. APPR.	9/	D3262	SHEET 4 OF 5					
APPROVED	143	TITLE	SCALE					
DE APPR.	-41-	FUEL PURGE CANISTER	NTS					
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Ø0.696<sup>+0.007</sup>

Ø0.588<sup>+0.005</sup>

-0.008

D3262-5 CAP

NOTES: 1) MATERIAL: 6061-T6/T651 ALUMINUM BAR PER QQ-A-200/8 OR QQ-A-225/8 REF. DART SPEC. M6061T6B

- 2) FINISH: NONE
  3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  4) UNITS: INCHES UNLESS OTHERWISE NOTED
  5) BREAK SHARP EDGES: 0.05 TO 0.010 MAX
  6) IDENTIFICATION: ENGRAVE 'DART LOGO AS SHOWN USING 0.75

6) IDENTIFICATION: ENGRAVE 'DART' LOGO AS SHOWN USING 0.75 HIGH x 0.010 DEEP	
(MAX) LETTERS WITH TOOL RADIUS OF 0.25 MIN	
7) WEIGHT: 0.27 lbs	
8) PART IS SYMMETRICAL ABOUT CENTERLINE	

DESIGN	RF	DART AEROSPACE LTD	ITD			
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA				
CHECKED	45.	DRAWING NO. REV.	Ε			
MFG. APPR.	91	D3262 SHEET 5 OF	5			
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